

**Work Order ID 68730**

Wednesday, April 20, 2011 11:15:28 AM



Page 1

Item ID: D3017-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Frame Assembly

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*M*

Date:

*11-04-20*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3017	Rev B								

100

Weld per dwg A/R 4130 rod Batch: *M102326* 0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017

2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)

3-Drill holes in D3017-5 Using DT8622

4-Deburr

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598

6-Drill holes in back frame using DT8621

*ER 11-5-2 (X1)*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

*1 0 BB11/05/02*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng				Sign & Date

**NOTE:** Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				(+)			
130  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M 115128 Memo START TIME: 1:00 OVEN TEMPERATURE: 320 FINISH TIME: 1:00	0.00 0.00				1	11-5-2		
140  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				1	11-5-2		

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**NOTE:** Date & initial all entries

**Work Order ID 68730**

Wednesday, April 20, 2011 11:15:28 AM



Page 3

Item ID: D3017-041

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Setup Start



Revision ID:

Stop



Item Name: Back Frame Assembly

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



Packaging

Packaging

Identify as per dwg & Stock Location: GA

0.00

Memo

Wp 68622

0.00

Ep 11/05/03 @

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/5/3011-05-3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, April 20, 2011 11:15:34 AM

Page 1

Work Order ID: 68730

Parent Item: D3017-041

Parent Item Name: Back Frame Assembly





Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A 01.09.19 New issue EC  
IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.083 		Purchased	No			100	f	6.5800	2.458	2.587368			
4130 RD Tube .750 x.083W													
m117579 x 2.5'				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT033		6.58							
				113812		6.58							
M4130NT0.750W.049 		Purchased	No			100	f	85.2300	11.125	11.71053			
4130 RD Tube .750 x.049W													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT033		85.23							
				10133		10.73							
				110740		74.5							
D3017-11 		Manufactured	No			100	Each	12.0000	2	2			
cap													
B69074 x 2				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA019		12							
				52583		12							
D3017-7 		Manufactured	No			100	Each	13.0000	3	3			
Lug													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA019		13							
				38567		2							
				52915		11							

W/O:		WORK ORDER CHANGES						
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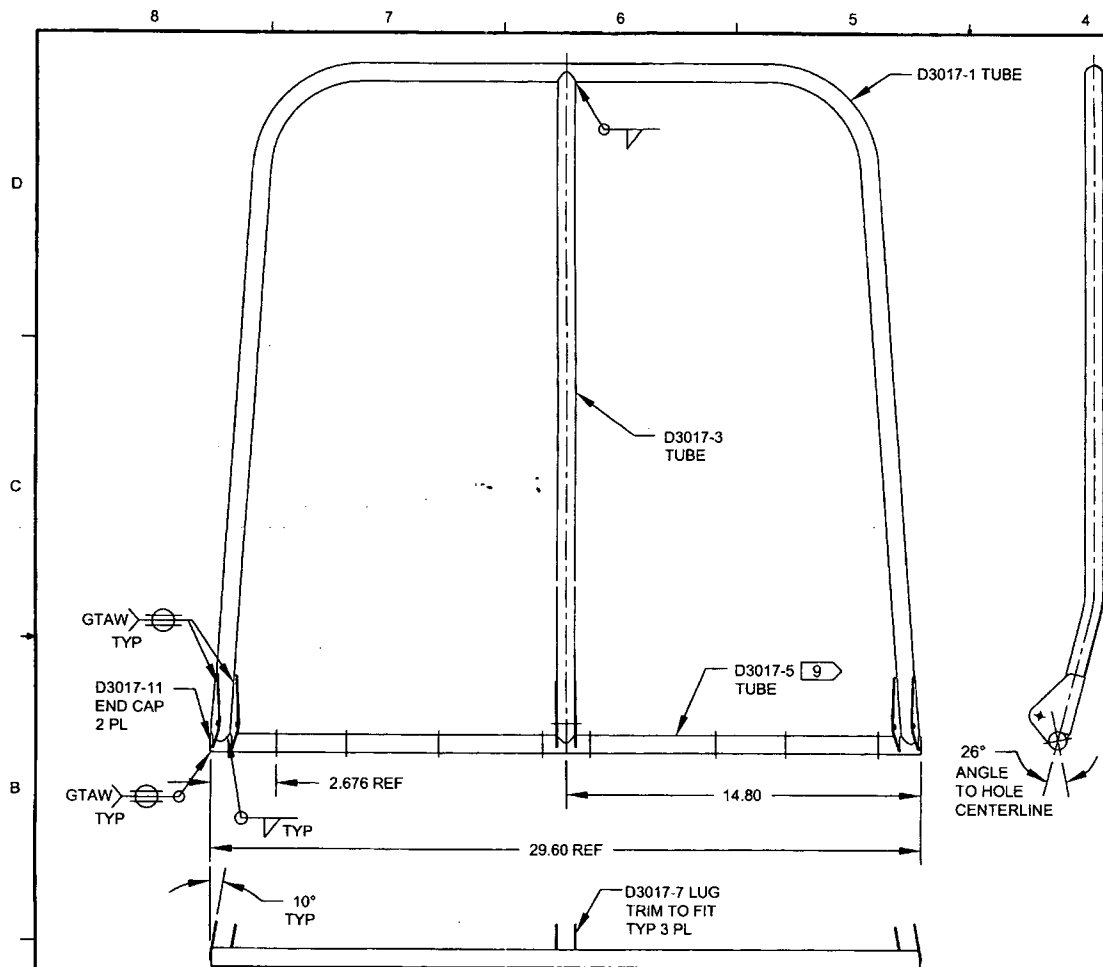
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





**D3017-041 BACK FRAME ASSEMBLY**

ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

**SHOT COPY**  
**RETURN TO**  
**ENGINEERING**  
**UNCONTROLLED COPY**  
**SUBJECT TO AMENDMENT**  
**WITHOUT NOTICE**  
**WORK ORDER**  
**NO. 68730**  
*211-04-20*

**RELEASED**  
**2010-02-02**  
*WJ*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

B	REFORMAT DWG, -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

**DART AEROSPACE LTD**  
**HAWKESBURY, ONTARIO, CANADA**

DRAWING NO. D3017  
 TITLE BACK FRAME ASSEMBLY  
 REV. B SHEET 1 OF 4  
 SCALE NTS

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W/O:		WORK ORDER CHANGES						
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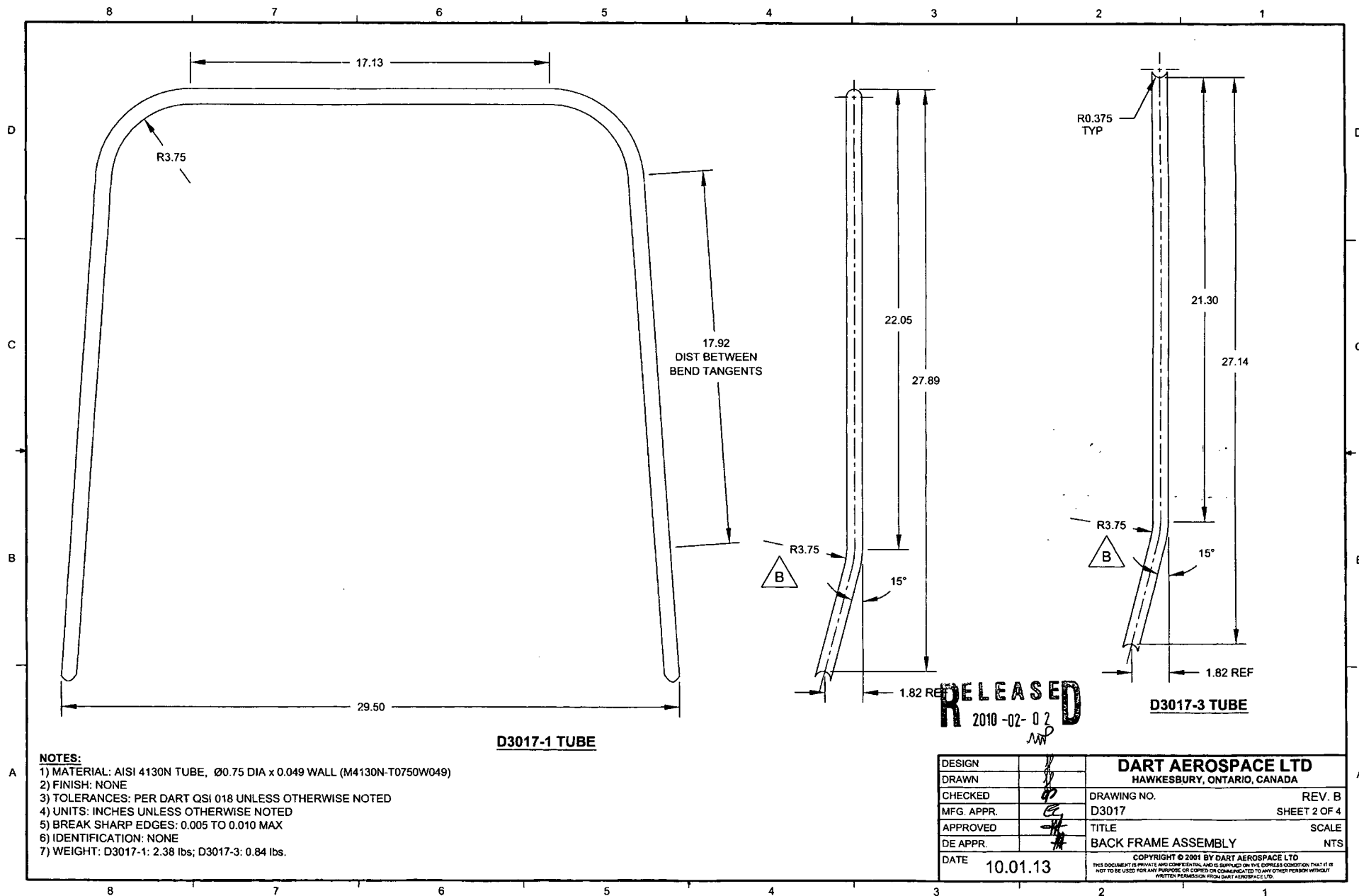
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**NOTE:** Date & initial all entries

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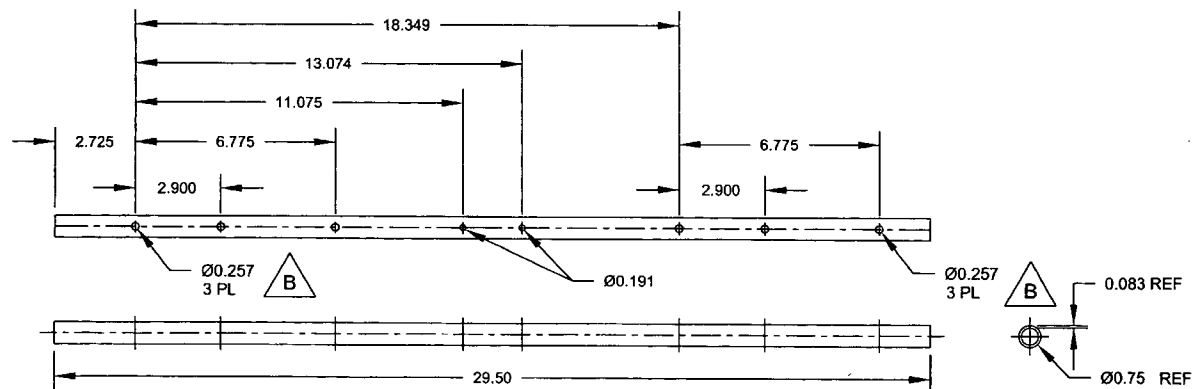
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u/648738



D3017-5 TUBE

RELEASED  
2010-02-02

**NOTES:**

- 1) MATERIAL: AISI 4130N TUBE,  $\varnothing 0.75$  DIA x 0.083 WALL (M4130N-T0750W083)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.89 lbs



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BACK FRAME ASSEMBLY	NTS
DATE	10.01.13	<small>COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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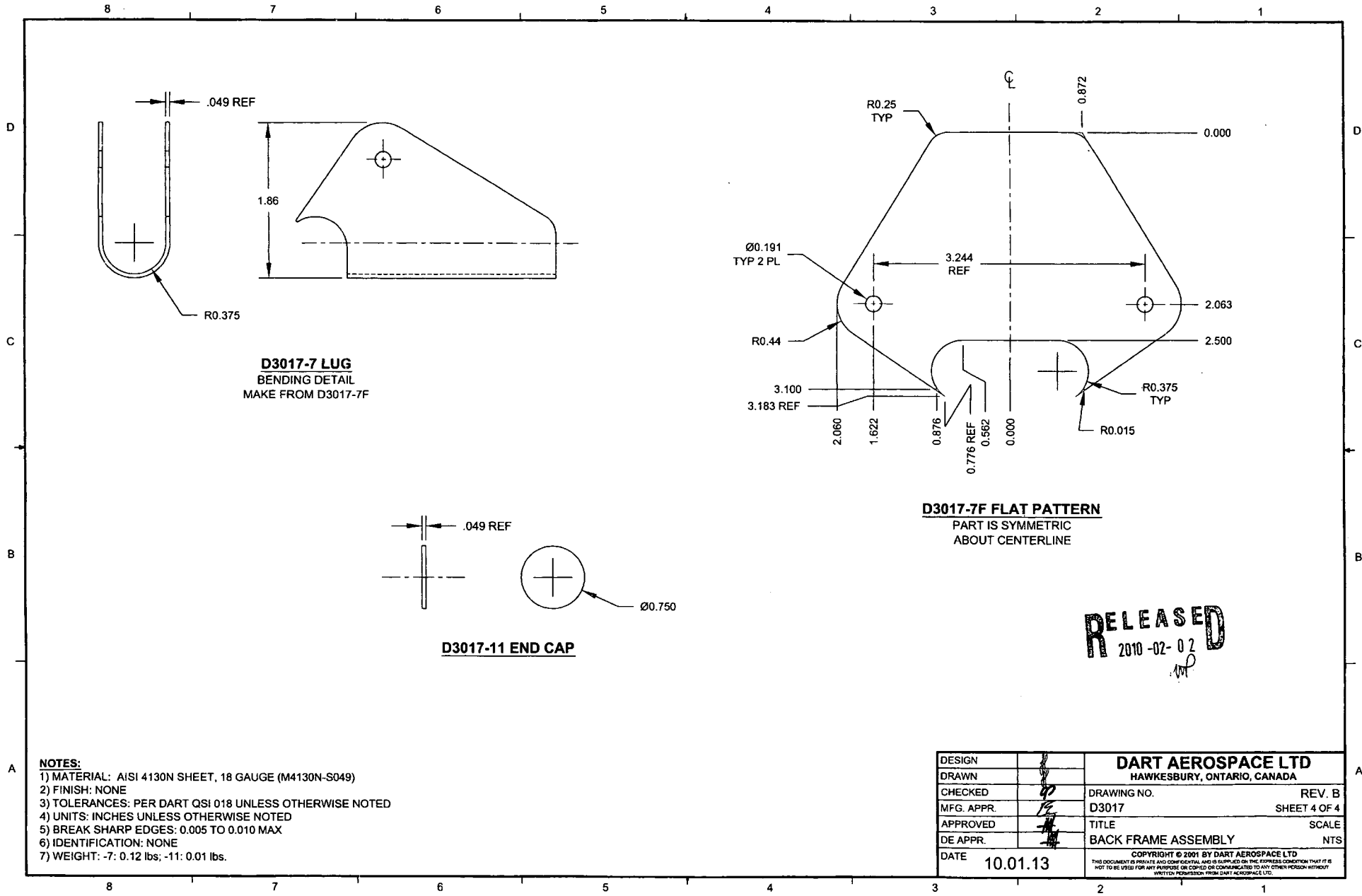
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W6 6823 d



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